

Date: Thursday, 3/30/2006 8:52:05 AM  
 User: Linda Lacelle

## Process Sheet

|  |  |
|--|--|
| <b>Customer</b> : CU-DAR001 Dart Helicopters Services    | <b>Drawing Name</b> : BLOWER MOTOR SUPPORT |
| <b>Job Number</b> : 26462                                |  |
| <b>Estimate Number</b> : 12308                           |  |
| <b>P.O. Number</b> : N/A                                 | <b>Part Number</b> : D34711                |
| <b>This Issue</b> : 3/30/2006 <b>S.O. No.</b> : N/A      | <b>Drawing Number</b> : D3471 REV.A        |
| <b>Prsht Rev.</b> : NC                                   | <b>Project Number</b> : N/A                |
| <b>First Issue</b> : N/A <b>Type</b> : SMALL /MED FAB    | <b>Drawing Revision</b> : A                |
| <b>Previous Run</b> : 26269                              | <b>Material</b> : N/A                      |
| <b>Written By</b> : SEE COMMENT BEKW                     | <b>Due Date</b> : 4/6/2006                 |
| <b>Checked &amp; Approved By</b> : SEE ABOVE USER & DATE | <b>Qty:</b> 1 <b>Um:</b> Each              |
| <b>Comment</b> : est rev A 06.03.02 New issue EC         |  |

## Additional Product

Job Number:



|                |                              |                      |
|----------------|------------------------------|----------------------|
| <b>Seq. #:</b> | <b>Machine Or Operation:</b> | <b>Description :</b> |
|----------------|------------------------------|----------------------|

|     |                 |                  |
|-----|-----------------|------------------|
| 1.0 | OUTSIDE SERVICE | OUTSIDE SERVICES |
|-----|-----------------|------------------|

**Comment:** Sub-Contracting OUTSIDE SERVICES

Issue P/O: \_\_\_\_\_

Email or Ship DXF file to vendor

Cut per Dwg D3471 flat pattern D3471-1F

possible supplier: GFI

Material release note required

MR02473-5063  
 made by Rand  
 Batch M 14279

SB 06/03/30 ①

|     |         |                   |
|-----|---------|-------------------|
| 2.0 | D34711F | BASE FLAT PATTERN |
|-----|---------|-------------------|

**Comment:** Qty.: 1.0000 sf(s)/Unit Total: 1.0000 sf(s)

SUPPORT FLAT PATTERN

|     |             |                       |
|-----|-------------|-----------------------|
| 3.0 | PACKAGING 1 | PACKAGING RESOURCE #1 |
|-----|-------------|-----------------------|

**Comment:** PACKAGING RESOURCE #1

Receive &amp; Inspect For Transit Damage

Ensure material certification is attached

|     |     |                   |
|-----|-----|-------------------|
| 4.0 | QC6 | DIMENSIONAL CHECK |
|-----|-----|-------------------|

**Comment:** DIMENSIONAL CHECK

Ensure Material certification comply to Dwg D3471

MR0603-30 ①

|     |             |                               |
|-----|-------------|-------------------------------|
| 5.0 | SMALL FAB 1 | SMALL & MEDIUM FAB RESOURCE 1 |
|-----|-------------|-------------------------------|

**Comment:** SMALL & MEDIUM FAB RESOURCE 1

1-Debur

2-Bend as per dwg D3471

SB

06/03/30 1

SB

06/03/30 ①

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## Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: BLOWER MOTOR SUPPORT

Job Number: 26462

Part Number: D34711

Job Number:



Seq. #:

Machine Or Operation:

Description :

6.0

HAND FINISHING1

HAND FINISHING RESOURCE #1



Comment: HAND FINISHING RESOURCE #1

Chemical Conversion Coat as per QSI 005 4.1

MA 06/03/30 (1)

7.0

QC5

INSPECT WORK TO CURRENT STEP



Comment: INSPECT WORK TO CURRENT STEP

IS 06/03/30 (1)

8.0

PACKAGING 1

PACKAGING RESOURCE #1



Comment: PACKAGING RESOURCE #1

Identify and Stock

Location: GA

SB 06/03/30 (1)

9.0

DC

DOCUMENT CONTROL



Comment: DOCUMENT CONTROL

Inspection Level 21

SD 06/03/30 (1)

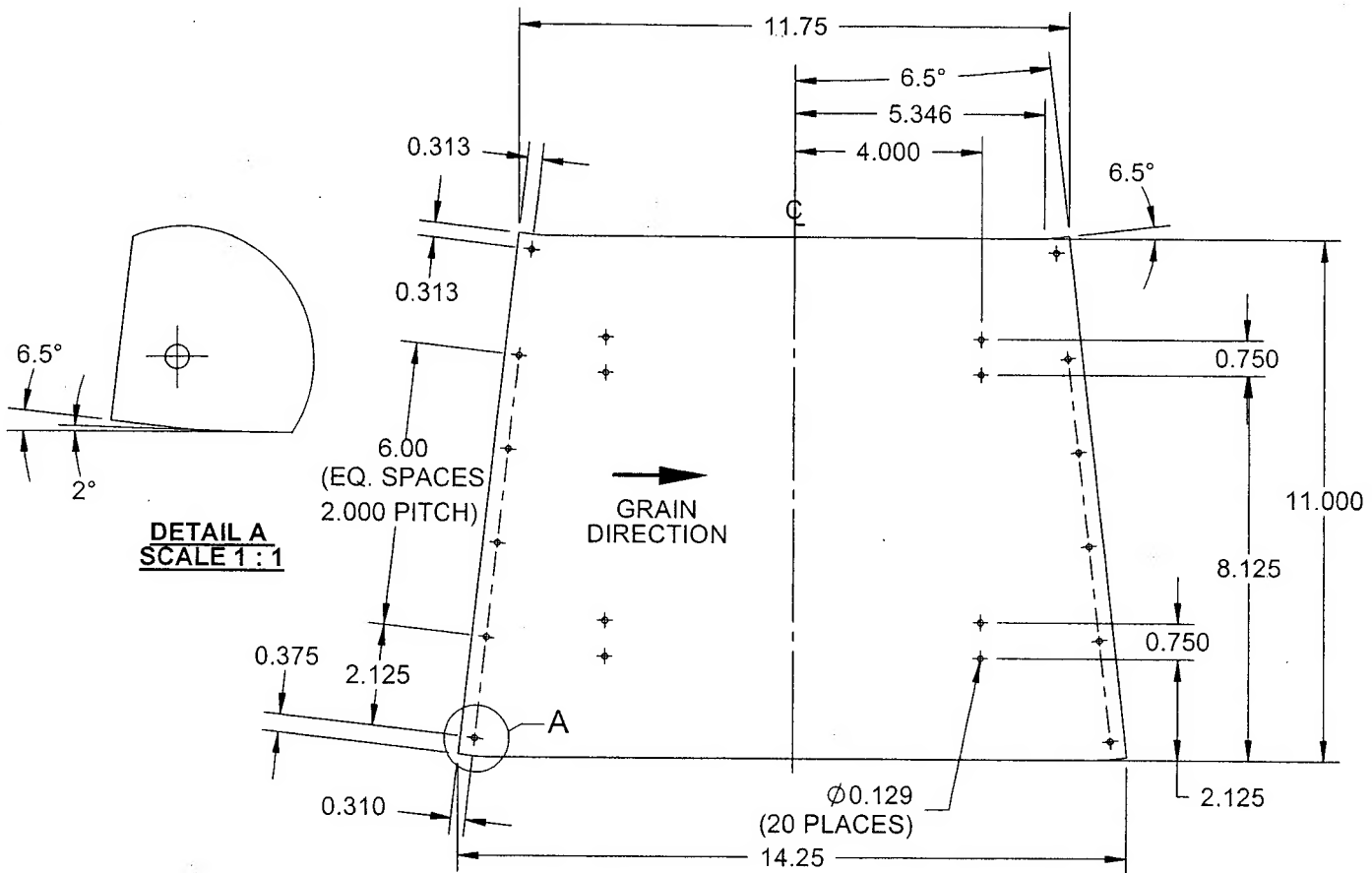
Job Completion



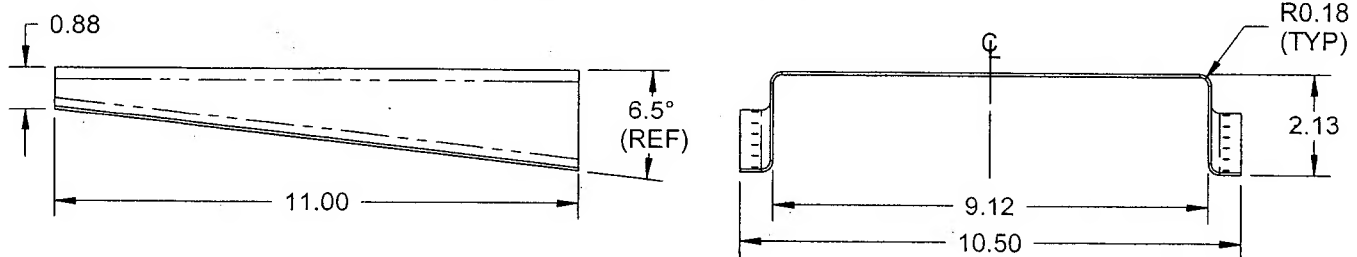
LA 06/03/30

PRELIMINARY ISSUE

|                  |                |   |                        |
|------------------|----------------|---|------------------------|
| DESIGN<br>13     | DRAWN BY<br>13 | DART AEROSPACE LTD<br>HAWKESBURY, ONTARIO, CANADA |                        |
| CHECKED          | APPROVED       | DRAWING NO.<br>D3471                              | REV. A<br>SHEET 3 OF 5 |
| DATE<br>05.12.21 |                | TITLE<br>BLOWER MOTOR SUPPORT                     | SCALE<br>1:4           |



**D3471-1F BASE FLAT PATTERN**



**D3471-1 BASE BENDING DETAIL**

**NOTES:**

- 1) MATERIAL: 2024-T3 ALUMINUM SHEET (0.063" THICK)  
PER QQ-A-250/4 OR AMS 4037  
(REF. DART SPEC. M2024T3S.063)
- 2) FINISH: CHEMICAL CONVERSION COAT PER DART QSI 005 4.1
- 3) PART IS SYMMETRICAL ABOUT CENTER LINE
- 4) ALL DIMENSIONS ARE IN INCHES
- 5) BREAK ALL SHARP EDGES 0.005 TO 0.010

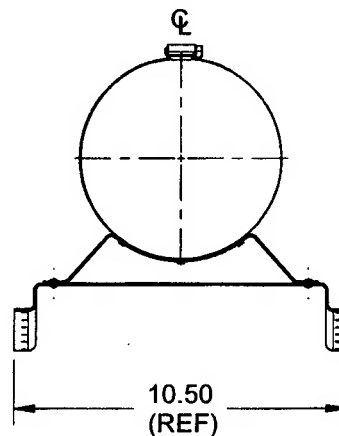
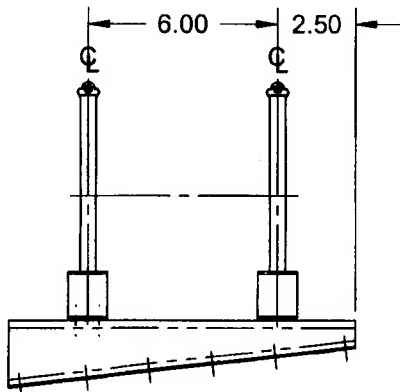
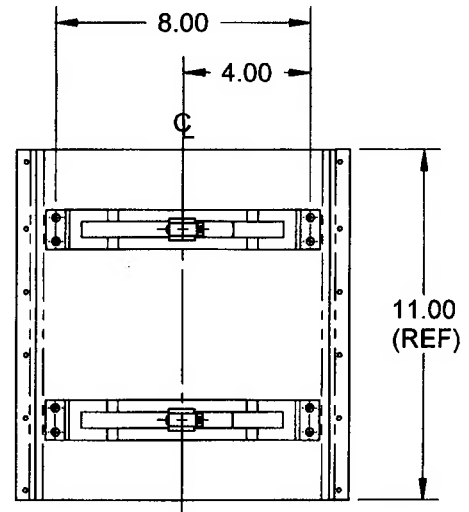
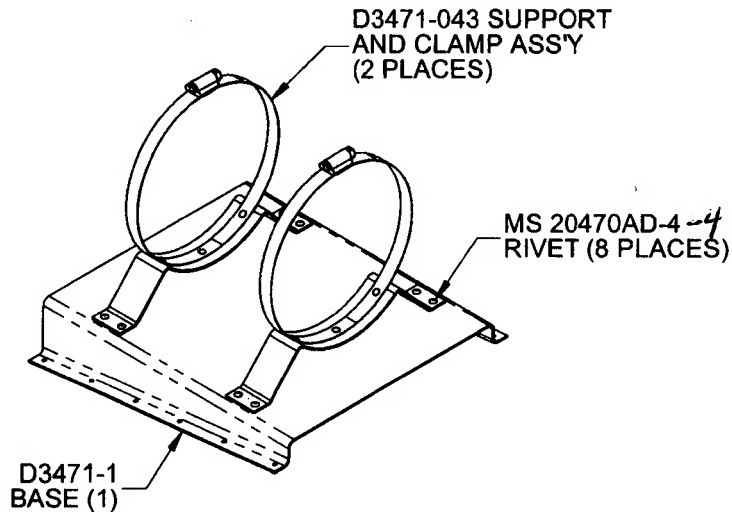
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**PRELIMINARY ISSUE**

|                         |                         |  |                        |
|-------------------------|-------------------------|--|------------------------|
| DESIGN<br>[Signature]   | DRAWN BY<br>[Signature] | <b>DART AEROSPACE LTD</b><br>HAWKESBURY, ONTARIO, CANADA |                        |
| CHECKED                 | APPROVED                | DRAWING NO.<br><b>D3471</b>                              | REV. A<br>SHEET 1 OF 5 |
| DATE<br><b>05.12.21</b> |                         | TITLE<br><b>BLOWER MOTOR SUPPORT</b>                     | SCALE<br>1:6           |
| A                       | 05.12.21                | NEW ISSUE  |                        |

M18729



### **D3471-041 BLOWER MOTOR SUPPORT**

#### **NOTES:**

- 1) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- 2) ALL DIMENSIONS ARE IN INCHES
- 3) BREAK ALL SHARP EDGES 0.005 TO 0.010

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